

# Work Order ID 66171

Monday, February 07, 2011 11:35:06 AM



Page 1

|                |                 |            |       |               |       |  |
|----------------|-----------------|------------|-------|---------------|-------|--|
| Item ID:       | D2530           | Accept     |       | Setup         | Start |  |
| Revision ID:   |                 |            |       |               | Stop  |  |
| Item Name:     | Handle Weldment |            |       |               |       |  |
| Start Date:    | 2/8/2011        | Start Qty: | 12.00 | Cust Item ID: |       |  |
| Required Date: | 2/22/2011       | Req'd Qty: | 12.00 | Customer:     |       |  |
| Reference:     |                 |            |       |               |       |  |

|            |               |           |       |                 |            |  |       |  |     |       |  |
|------------|---------------|-----------|-------|-----------------|------------|--|-------|--|-----|-------|--|
| Approvals: | Process Plan: | <u>MF</u> | Date: | <u>11-02-07</u> | Tooling:   |  | Date: |  | Run | Start |  |
|            | QC:           |           | Date: |                 | SPC (Y/N): |  | Date: |  |     | Stop  |  |

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|          |              |  |  |  |  |  |  |  |  |
|----------|--------------|--|--|--|--|--|--|--|--|
| Draw Nbr | Revision Nbr |  |  |  |  |  |  |  |  |
| D2530    | Rev B        |  |  |  |  |  |  |  |  |

|     |  |           |      |  |  |  |  |  |  |  |
|-----|--|-----------|------|--|--|--|--|--|--|--|
| 100 |  | Small Fab | 0.00 |  |  |  |  |  |  |  |
|     |  | Small Fab | 0.00 |  |  |  |  |  |  |  |
|     |  | Small Fab | 0.00 |  |  |  |  |  |  |  |

Memo  
1-Cut to length as per Dwg D2536  
2-Deburr

⇒ m-k 11/02/17

|     |  |                                    |      |  |  |  |  |  |  |  |
|-----|--|------------------------------------|------|--|--|--|--|--|--|--|
| 110 |  | QC6- Inspect dimensions to drawing | 0.00 |  |  |  |  |  |  |  |
|     |  | QC                                 | 0.00 |  |  |  |  |  |  |  |
|     |  | Quality Control                    |      |  |  |  |  |  |  |  |

Memo

Sub 2/17

|     |  |  |      |  |  |  |  |  |  |  |
|-----|--|--|------|--|--|--|--|--|--|--|
| 120 |  | Weld per dwg A/R S.S. rod Batch: <u>115908</u> | 0.00 |  |  |  |  |  |  |  |
|     |  | Small Fab                                      |      |  |  |  |  |  |  |  |
|     |  | Large Fab                                      | 0.00 |  |  |  |  |  |  |  |
|     |  | Large Fab                                      |      |  |  |  |  |  |  |  |

Memo

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

PC 11.03.08

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. Once the problem is identified, the next step is to analyze it. This involves breaking the problem down into its components and understanding the underlying causes.

3. After analyzing the problem, the next step is to develop a plan. This involves determining the steps that need to be taken to solve the problem.

4. The final step is to implement the plan. This involves putting the plan into action and monitoring the progress.

Page 2

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(b) (5) DPP, (b) (5) ACP

**Abstract**

[illegible][illegible]

**Reference:**

[illegible]

**Insp.  
Stamp**

11.03.08

[illegible]

0.00

## Quality Control

0.00

11-11-11 11-11-11 11-11-11 11-11-11 11-11-11

0.00

## Quality Control

0.00

**00000000000000000000**

0.00

## Powder Coating

START TIME: 1:00  
OVEN TEMPERATURE: 320°  
FINISH TIME: 1:30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 66171**

Monday, February 07, 2011 11:35:06 AM

Page 3

Item ID: D2530

Accept

Revision ID:

Item Name: Handle Weldment

Start Date: 2/8/2011 Start Qty: 12.00

Required Date: 2/22/2011 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

12 6 22 4/03/09

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 506

0.00

Memo

0.00

10/3/10 (12)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/10

11-03-10 (12)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, February 07, 2011 11:35:01 AM

Page 1

Work Order ID: 66171

Parent Item: D2530

Parent Item Name: Handle Weldment

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F  
11.01.07 chg qc 5 to 6 DD verf:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

|  |  |              |    |  |  |     |      |         |   |    |  |  |  |
|--|--|--------------|----|--|--|-----|------|---------|---|----|--|--|--|
| D2534  |  | Manufactured | No |  |  | 120 | Each | 14.0000 | 2 | 24 |  |  |  |
|  |  |              |    |  |  |     |      |         |   |    |  |  |  |
| Lock Plate   |  |              |    |  |  |     |      |         |   |    |  |  |  |

*Pl 11.03.08*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA020    | 14      |          |
| 64929    | 14      |          |

*B 66807 → 10*

|  |           |    |  |  |     |   |         |        |          |  |  |  |  |
|--|-----------|----|--|--|-----|---|---------|--------|----------|--|--|--|--|
| M304TR0.750W.049   | Purchased | No |  |  | 100 | f | 75.3552 | 2.9145 | 36.81474 |  |  |  |  |
|  |           |    |  |  |     |   |         |        |          |  |  |  |  |
| 304 RD Tube .750 x .049W   |           |    |  |  |     |   |         |        |          |  |  |  |  |

*M 11/02/17*

| Location            | Loc Qty   | Loc Code |
|---------------------|-----------|----------|
| MAT                 | 69.735195 |          |
| 108498              | 0         |          |
| 110113              | 0         |          |
| 115010              | 15.074255 |          |
| <i>B/B</i> 116108 ✓ | 14.66094  |          |
| 116720              | 40        |          |
| MAT014              | 0.00003   |          |
| 115990              | 0.00003   |          |
| MAT017              | 5.62      |          |
| 109314              | 4.33      |          |
| 110113              | 1.29      |          |

*36.81474 \**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**DART**

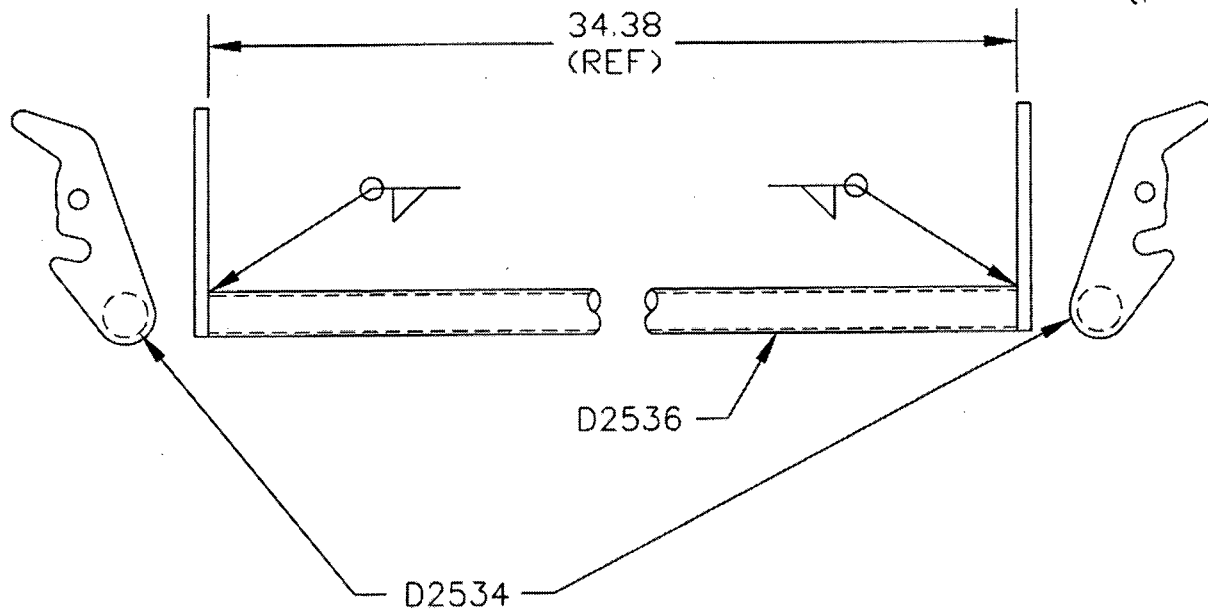
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|----------------------------|-----------------------------|--|------------------------|
| DESIGN                     | DRAWN BY                    | DART AEROSPACE LTD                     |                        |
| B WILLIAMS                 | PH                          | VICTORIA INTERNATIONAL AIRPORT, CANADA |                        |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO.<br>D2530                   | REV. B<br>SHEET 1 OF 1 |
| DATE<br>04.12.14           |                             | TITLE<br>HANDLE WELDMENT               | SCALE                  |
| A                          | 96.06.18                    | NEW ISSUE                              |                        |
| B                          | 04.12.14                    | UPDATE NOTES AND DIMENSIONS            |                        |

RELEASED

04.12.16 *[Signature]*

## PART LIST -- D2530

| QTY | PART NUMBER | DESCRIPTION     |
|-----|-------------|-----------------|
| X   | D2530       | HANDLE WELDMENT |
|     |             |                 |
| 1   | D2536       | HANDLE          |
| 2   | D2534       | LOCK PLATE      |

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries